

SPUT

Date: Tuesday, 27/01/2009 10:33:27 AM
User: Linda Lacelle

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: TAIL LIGHT FAIRING
Job Number	: 44096	Part Number	: D3484042
Estimate Number	: 12418	Drawing Number	: D3484 REV E
P.O. Number	:	Project Number	: N/A
This Issue	: 27/01/2009 S.O. No. :	Drawing Revision	: E
Prsht Rev.	: NC	Material	:
First Issue	: 15/12/2008 Type : LARGE FAB ASSY	Due Date	: 22/12/2008
Previous Run	: 43277	Qty:	8 Um: Each
Written By	:		
Checked & Approved By	:		
Comment	: Est Rev:A New Issue 06-05-23 EC Est Rev:B 08-01-24 change rivet for CR1122-3-025 DD verified by:EC		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D34842	Base, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
BASE, RH
Batch: B44171

SP 09.01.27

2.0	D34844	Face, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
FACE, RH
Batch: B43252

SP 09.01.27

3.0	D34846	Cone, RH
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 3.0000 Each(s)
CONE, RH
Batch: B36403

SP 09.01.27

4.0	LARGE FAB 1	LARGE FABRICATION RESOURCE 1
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Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per Dwg D3484 using DT8880 Jig
A/R AL ROD Batch: H104855

SP 09.01.29 (2X)

2-Buff & Smooth Welds to mating surfaces

Date: Tuesday, 27/01/2009 10:33:28 AM
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Drawing Name: TAIL LIGHT FAIRING

Job Number: 44096

Part Number: D3484042

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

PD 09-01-29 (2)

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

PTO on last page attached.
S 09/02/02 (40)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

FL 09/02/02

(1)

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

MF 09-02-07

9.0

CR1122 3 025

RIVET



Comment: Qty.: 4.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rivet

Batch: 106878

FF 09/02/02

(1)

10.0

MS2106904

ANCHOR NUT



Comment: Qty.: 2.0000 Each(s)/Unit Total : 6.0000 Each(s)

ANCHOR NUT

Batch: 103693

FF 09/02/02

(1)

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Install Nut Plates as per Dwg D3484

FF 09/02/02

(1)

12.0

QC5

INSPECT WORK TO CURRENT STEP




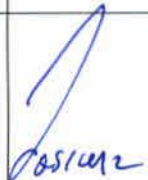



Comment: INSPECT WORK TO CURRENT STEP

S 09/02/02 (12H)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D3184-042 PAR #: N/A Fault Category: Prod / Fin. Large NCR: Yes No DQA: D Date: 09/02/03
 Resolution: Re-work Disposition: Re-work QA: N/C Closed: D Date: 09/02/03

NCR: <u>44096</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
09-01-30	6.0	Upon inspection it was found 1 part has numerous tiny cracks up to 2.5~ along the welded area. Too much material was ground off. R.C. Human error. Lack of Attention.		- Re-weld the affected area. - More weld: less grinding on the overall part will be acceptable.	 09.02.03	 09/02/03	 09/02/03	 09-01-30

NOTE: Date & initial all entries

Date: Tuesday, 27/01/2009 10:33:28 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: TAIL LIGHT FAIRING

Job Number: 44096

Part Number: D3484042

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

POWDER COATING

POWDER COATING



m 109996



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

①

START TIME:

7:30

OVEN TEMPERATURE:

320°

FINISH TIME:

8:00

FL 09/02/03

14.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



①

Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

FL 09-02-03

15.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

Identify on inside surface as indicated

TCCA-PDA, DART AEROSPACE LTD

P/N: D412-750-142 B/N: BXXXXX

FOR PRODUCT ELIGIBILITY SEE PDA06-13

09/02/03

16.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

09/02/03 (LTH)

17.0

QC21

FINAL INSPECTION/W/O RELEASE



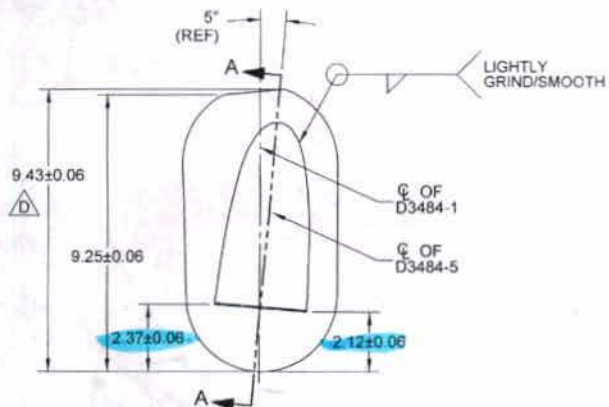
Comment: FINAL INSPECTION/W/O RELEASE

09/02/03

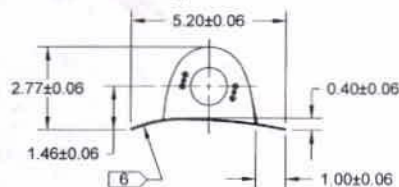
Job Completion



MF 09-02-03

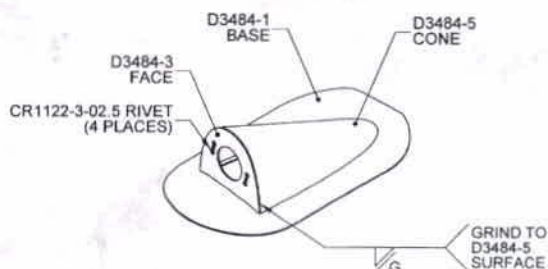


QTY -041	QTY -042	P/N	DESCRIPTION
X		D3484-041	TAIL LIGHT FAIRING ASSEMBLY (LH)
	X	D3484-042	TAIL LIGHT FAIRING ASSEMBLY (RH)
1		D3484-1	BASE (LH)
	1	D3484-2	BASE (RH)
1		D3484-3	FACE (LH)
	1	D3484-4	FACE (RH)
1		D3484-5	CONE (LH)
	1	D3484-6	CONE (RH)
4	4	CR1122-3-02.5	RIVET
2	2	MS21069-04	ANCHOR NUT



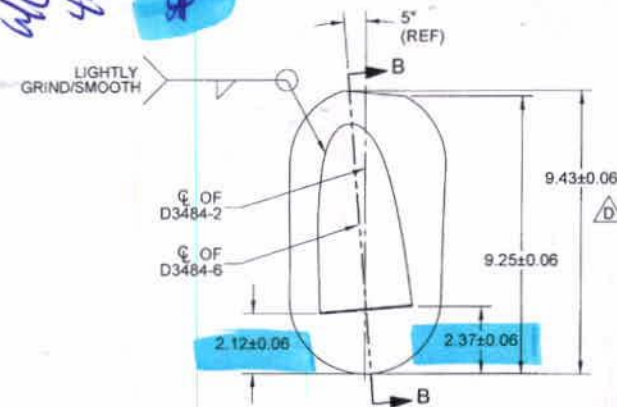
SECTION A-A

D3484-041 TAIL LIGHT FAIRING

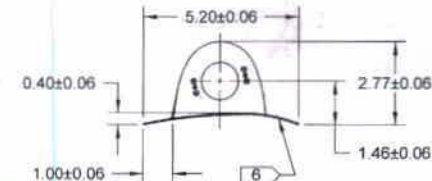


D3484-041 ISOMETRIC VIEW

- NOTES:
- 1) MATERIAL: N/A
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) WELDING: PER DART QSI 004
 - 6) IDENTIFICATION: IDENTIFY ON INSIDE SURFACE AS INDICATED WITH WHITE LABEL:
"TCCA-PDA, DART AEROSPACE LTD., P/N D412-750-141/-142 B/N BXXXXX, FOR PRODUCT ELIGIBILITY SEE PDA06-13"
 - 7) WEIGHT: 0.30 lbs

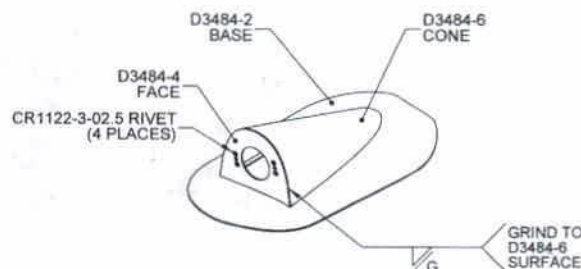


INSTALL MS21069-04
ANCHOR NUT
(2 PLACES)



SECTION B-B

D3484-042 TAIL LIGHT FAIRING

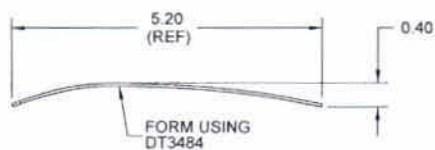
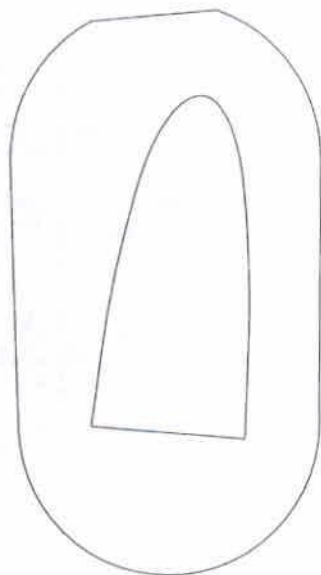


D3484-042 ISOMETRIC VIEW

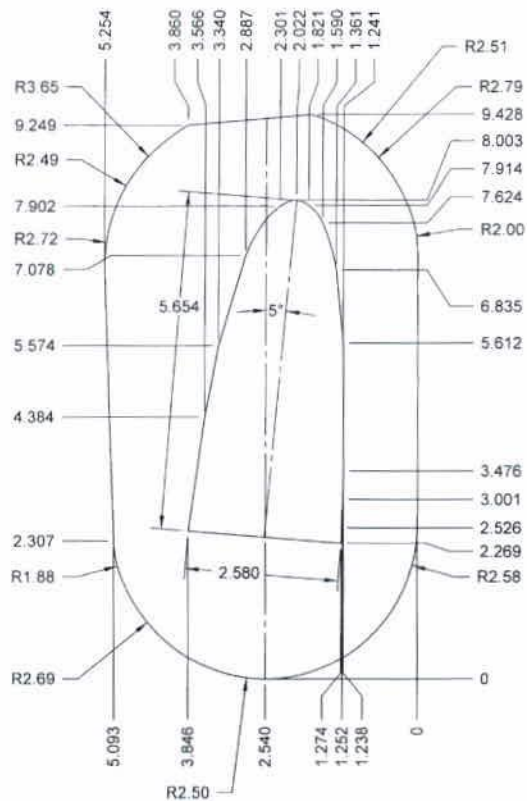
E	REDRAWN/REFORMAT TO SHOW LH AND RH CONFIGURATIONS FOR CLARITY. CORRECT VIEWS ON SHEET 3 & 4 (WAS SHOWING MIRROR IMAGE OF PARTS): DIM 1.560 WAS 1.563 (SHEET 3, ZONE B4), CR1122-3-02.5 RIVET WAS MS20426AD3-3 RIVET	MB	08.01.03
D	CORRECT D3484-1F	MB	06.06.22
C	RE-DESIGN D3484-3F1-5F	MB	06.04.20
B	RE-DESIGN	MB	06.02.21
A	NEW ISSUE	MB	05.11.29
REV	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	08.01.03		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D3484	REV. E
TITLE TAIL LIGHT FAIRING	SHEET 1 OF 4
SCALE 1:4	

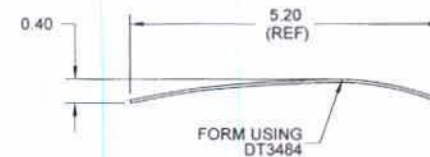
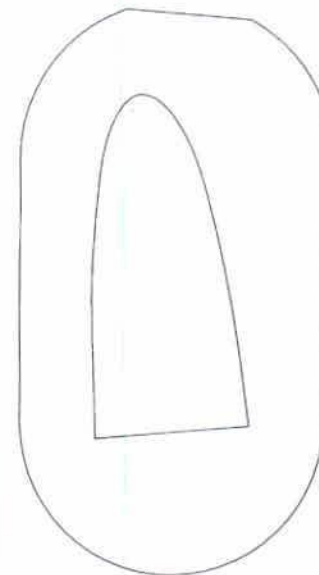
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D3484-1 BASE
(MAKE FROM D3484-1F)



D3484-1F BASE FLAT PATTERN

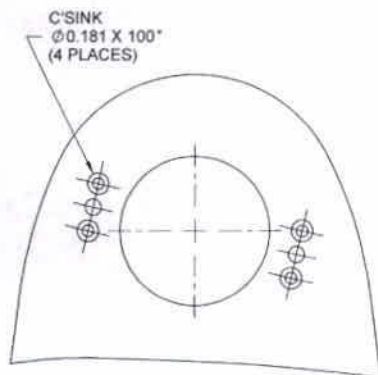


D3484-2 BASE
(MAKE FROM D3484-1F)

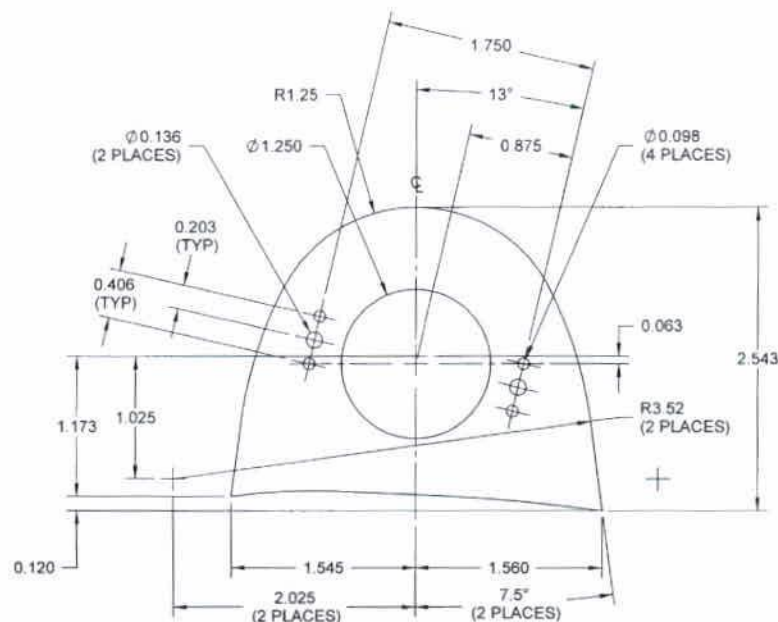
- NOTES:**
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
 - 2) FINISH: N/A
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.16 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3484	REV. E
MFG. APPR		TITLE TAIL LIGHT FAIRING	SHEET 2 OF 4
APPROVED		SCALE 1:2	
DE APPR.			
DATE	08.01.03		

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D3484-3 FACE
(MAKE FROM D3484-3F)



D3484-3F FLAT PATTERN TAIL LIGHT FAIRING

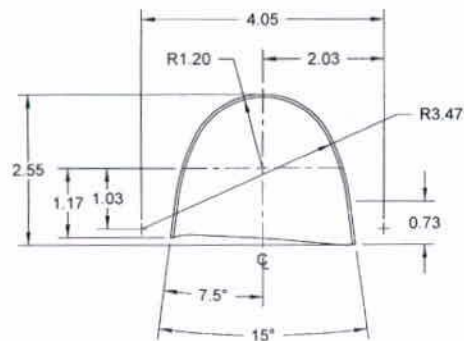
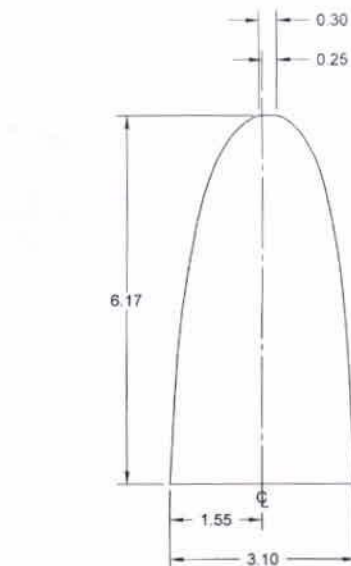


D3484-4 FACE
(MAKE FROM D3484-3F)

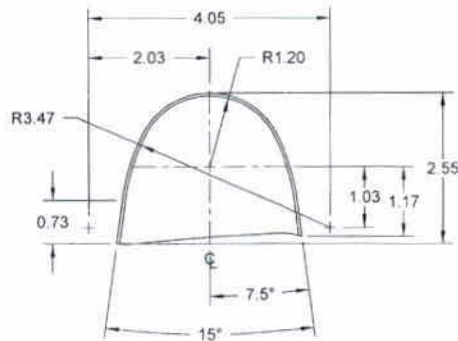
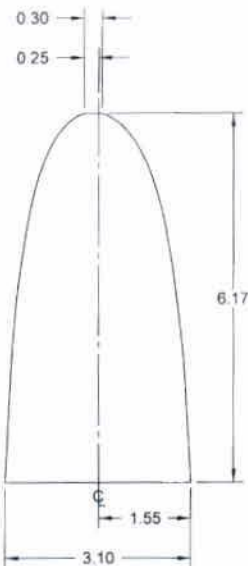
NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.02 lbs

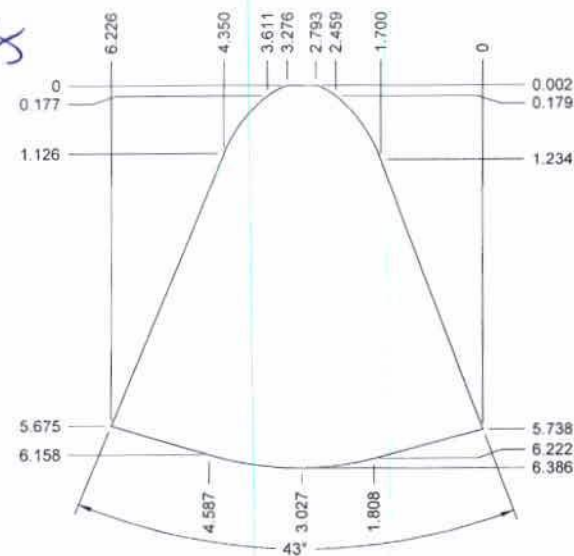
DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO	REV. E
MFG. APPR.		D3484	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		TAIL LIGHT FAIRING	1:1
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D3484-5 CONE
(MAKE FROM D3484-5F)



D3484-6 CONE
(MAKE FROM D3484-5F)



D3484-5F CONE FLAT PATTERN

NOTES:

- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET (0.050 THICK)
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027
(REF. DART SPEC. M6061T6S.050)
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3484	REV. E
MFG APPR.		TITLE	SHEET 4 OF 4
APPROVED		TAIL LIGHT FAIRING	SCALE
DE APPR.			1:2
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